

Ship Inge 7-8

Work Order ID 59463



June 4, 2010 11:50:38 AM

Item ID: D4122-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Fwd

Start Date: 6/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/07/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4122

A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B 10-6-7

①

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-6-4

Pro →

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 10106107

④

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4122-1 PAR #: Fault Category: Pre-Eng cancel. NCR: Yes No DQA: Date: 10.06.10
 Resolution: rework Disposition: rework QA: N/C Closed: Date: 10/06/10

NCR: 59463		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
100607	100	while cutting one of the long slots on the water jet, the slot was cut too long and deformed by .200	<u>CP</u> 10.06.07 per OS 642	used die grinder to machine and blend slot to 78.95	<u> </u> 100607	<u>S</u> 10/06/07	<u> </u> 07 Jun 10	<u>S</u> 10/06/07
		act Dwg. 78.75 actual 78.95 RL Program error.	<u>CP</u> 10.06.07	→ Fix Program DXF WAS wrong	<u> </u> 10.06.07		<u>CP</u> 10.06.07 per OS 642	<u>S</u> 10/06/07

NOTE: Date & initial all entries

Work Order ID 59463

June 4, 2010 11:50:38 AM

Page 2

Item ID: D4122-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Floor Protector, Fwd

Start Date: 6/04/10

Start Qty: 1.00

Cust Item ID:

Required Date: 6/07/10

Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

Handwritten signature
6/10/06/07

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Handwritten: 8.06667

Handwritten circled 'H'

150

0.00



Identify as per dwg & Stock Location:

Packaging

Memo

0.00

Packaging

Handwritten: PPP 59466

Handwritten signature
6/4/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

June 4, 2010 11:50:38 AM

Page 1

Work Order ID: 59463



Parent Item: D4122-1



Parent Item Name: Floor Protector, Fwd

Start Date: 6/04/10

Required Date: 6/07/10

Comments: IPP Rev:A 10.06.04 new issue DD verf:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,762.106	27.143	28.57158			



GE PLASTICS LEXAN SHEET

1310-67

Location

Loc Qty

Loc Code

MAT

1762.1068

111710

64

112585

165.783

114032

1532.3238

114032

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	S9463
Description: FLOOR PROTECTOR FWD		Part Number:	D4122-1
Inspection Dwg: D4122-1 Rev: A		Page 1 of 2	

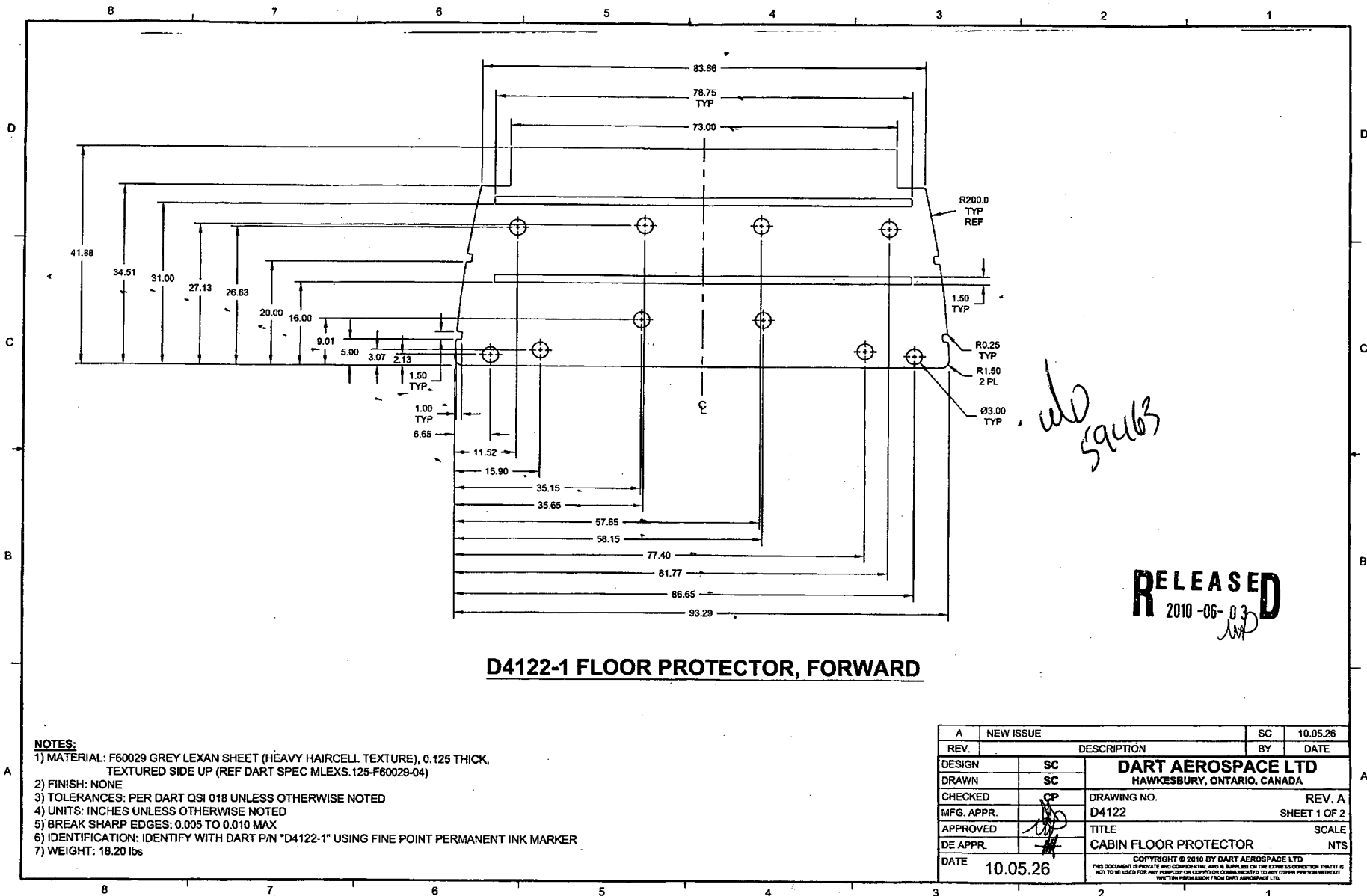
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	+0.012 - 0.001	3.001	>			
83.66	± .030	83.66	>			
78.75	± .030	78.75	>		78.95"	see Back of Page #1
73.00	± .030	73.00	>			
1.50	± .030	1.507	>			
41.88	± .030	41.88	>			
34.51	± .030	34.51	>			
31.00	± .030	31.00	>			
27.13	± .030	27.13	>			
26.63	± .030	26.63	>			
20.00	± .030	20.00	>			
16.00	± .030	16.00	>			
9.01	± .030	9.01	>			
3.07	± .030	3.07	>			
2.13	± .030	2.13	>			
1.50	± .030	1.50	>			
1.00	± .030	1.00	>			
6.65	± .030	6.65	>			
11.52	± .030	11.52	>			
15.90	± .030	15.90	>			
35.15	± .030	35.15	>			
35.65	± .030	35.65	>			
57.65	± .030	57.65	>			

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 10-6-7	Date: 10/06/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



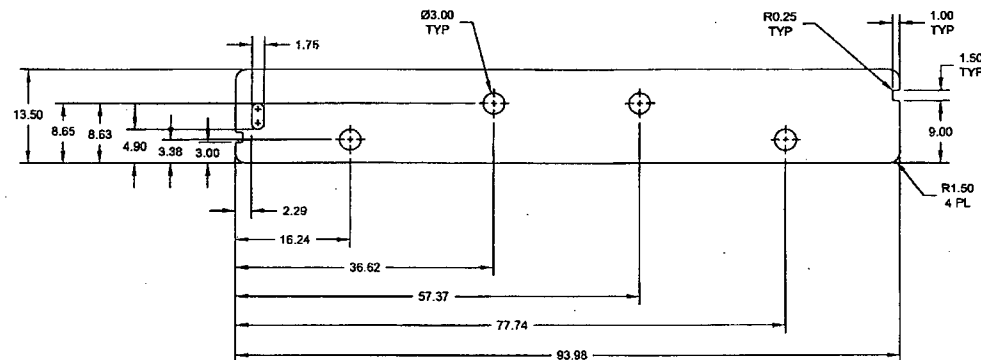
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NOTE: Date & initial all entries




D4122-3 FLOOR PROTECTOR, AFT

WLO
59463

RELEASED
2010-06-03
MP

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4122-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 6.79 lbs

DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.		D4122	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
DATE	10.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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